

particularly large size, and it is planed at the places where it has a bearing on the jig body.

Fig. 20 shows a closed jig about which there can be no doubt but that it should be classified as a box jig. The piece of work drilled, the foot trip *A*, has two holes *B* and *C* which are drilled in this jig. The cylindrical hub of the work is located against V-blocks and held in place by a swinging strap *D*. The work is further located against a stop-pin placed opposite the set-screw *E*. The trip is located sidewise by being brought against another

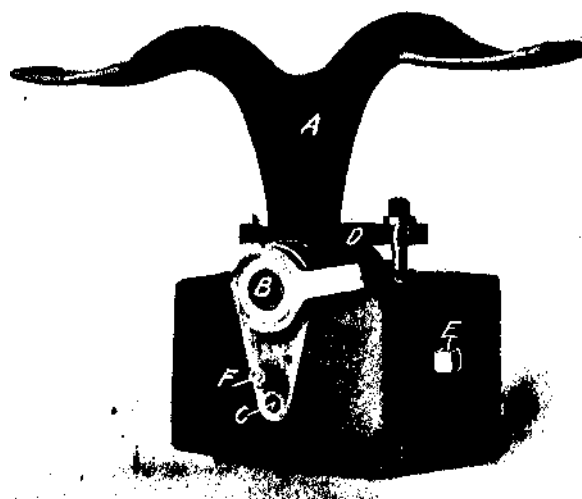


Fig. 20. Jig shown in Detail in Fig. 19

stop by the set-screw *F*. One-quarter of a turn of the collar-head screw on the top of the jig releases the swinging strap which is then turned out of the way; this permits the trip to be removed and another to be inserted. Half a turn or less of the set-screws is enough to release and clamp the work against the stops mentioned. A line engraving of this jig is shown in Fig. 19 which gives a better idea of some of the details of the construction.

In Figs. 21 and 22 are shown two views of another type of closed drill jig. The work -4, to be drilled, is shown at the left